

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016342**Date Inspected:** 03-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 25 located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3F/F. Welder is identified as 066115. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3313 – TC – P5.

Weld joint # 14 located on South tower Lift-5 Grillage Assembly SSD1 – TL5 – 1B/F. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.

Weld joint # 27B located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3F/F. Welder is identified as 066443. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3313 – TC – P5.

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Repair welding of a weld joint # 5B located on South tower Lift-5 Grillage Assembly SSD1 – TL5 – 1E/F. Welder is identified as 056200. ZPMC Quality Control (QC) Inspector is identified as Sun Tian Liang. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 3G (3F) – Repair. (See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 2A located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 17. Welder is identified as 054465. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 1A located on Lift-5 Splice Plate Stiffener ESD1 – SPSA5 – 17. Welder is identified as 046704. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 3B located on Lift-5 Splice Plate Stiffener WSD1 – SPSA5 – 7. Welder is identified as 040656. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

Weld joint # 13 located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U4c.

Weld joint #9A located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4E/F. Welder is identified as 066258. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

Repair welding of a weld joint # 20A located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2E/F. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 3G (3F) – Repair.

Weld joint # 8B located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4E/F. Welder is identified as 067993. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC – U5b.

ORTHOTROPIC BOX GIRDER (OBG) LIFT-13 AT BAY#11

This QA Inspector observed the following work in progress

Fluxcored Arc Welding (FCAW):

Weld joint # 094 located on Bike Path panel Assembly BK004A6– 019. Welder is identified as 042218. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

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Repair welding of a weld joint # 42 located on Side Plate SP3107 – 001 as per the critical weld repair report # B-CWR1751. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Shang Hai Long. The welding variables recorded by QC appeared to comply with the WPS – 345 – FCAW – 2G (2F) – Repair. (See attached photo)

Weld joint # 075 located on Bike Path panel Assembly BK005A6– 002. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
